

Work Order ID 130894

March-26-15 1:27:28 PM

646.8013
B130894
REV. N/C

130894

Page 1

Item ID: 646.3013

Revision ID:

Item Name: Blade

Start Date: 3/26/15

Start Qty: 6.00

6

Required Date: 3/26/15

Req'd Qty: 6.00

6

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MJS

Date: 5-3-26

Tooling:

Date:

QC:

Date:

SPC.(Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.3000

N/C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.01

Jeaspa Bandsaw

Cut Blank at 4.930"

6 JLS-3-20

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.07

HAAS CNC vertical machine #1

1-Machine per folio FB150

DWG REV: MJS

FOLIO REV: AA

6 JLS-4-7

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL
BURRS ON CUTTING EDGE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130894

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130894

Page 2

Item ID: 646.3013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade
 Start Date: 3/26/15 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				6			215-47
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				6	0		DAS 14 9-89 15/04/08
140 *140* Outsource1 Outsource process - Heat Treat	Outsource process - Heat Treat Memo HEAT TREAT AS PER DWG, SEE NOTE #3 ISSUE P/O: <u>28086</u>	0.00 4.80				CZ			APR 13 2015 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Page 4

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 Revision ID: Stop ***NS2***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC14- Inspect Spray Paint	0.00							DAS 38 2-89
170						(6)			
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>mf</u>	0.00							
180						6			DAS 27 2-89
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190						ML5			MAY 0 5 2015
QC	Memo	0.00							
Quality Control									

MAY 0 1 2015

MAY 0 5 2015

ML5 MAY 0 5 2015

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

March-26-15 1:27:27 PM

Page 1

Work Order ID: 130894

130894

Parent Item: 646.3013

646 3013

Parent Item Name: Blade

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 12/11/09 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased	No			100	f	149.2170	0.411	2.59579			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

SL15-3-30

Location

Loc Qty

Loc Code

MAT010

149.217

M126438

21.217

M131783

128

2.53

DQA: _____ Date: _____



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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

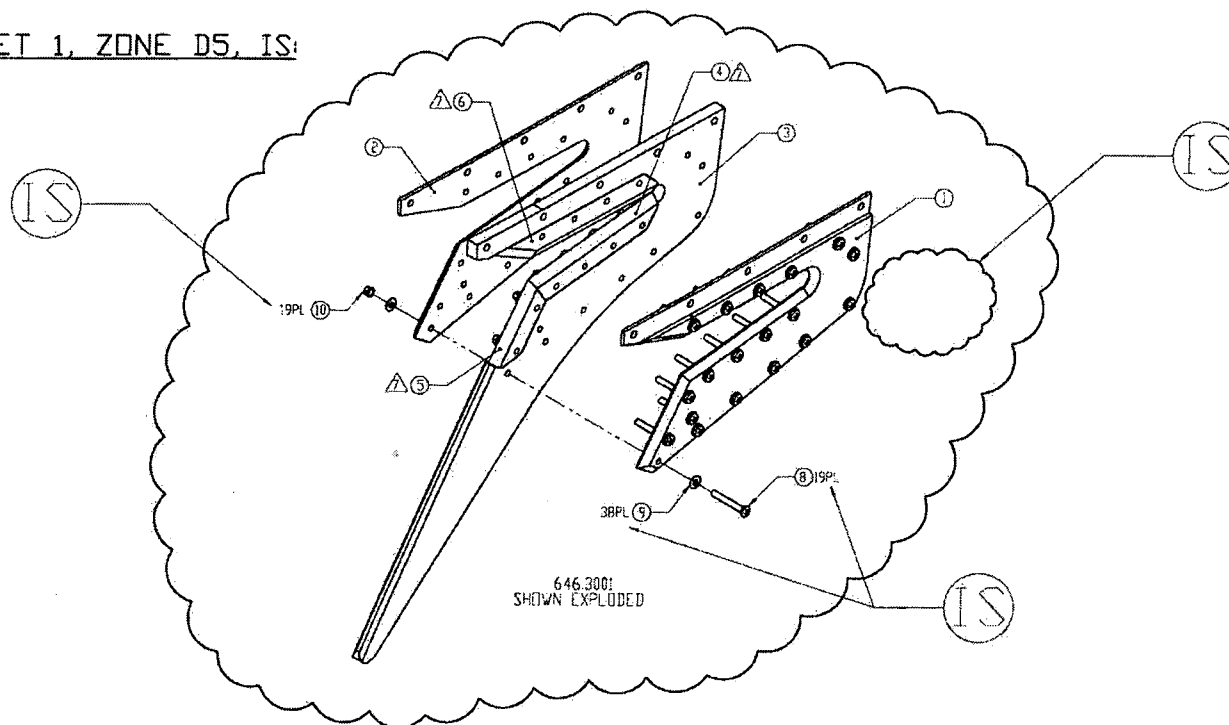
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 02195		SHEET 1 OF 4	
DWG NO. 646.3000	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
DWG TITLE: LOWER CUTTER ASSY		EFFECT ON DWG ☐ INC. ☒ UNINC.	
APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER
REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS			

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

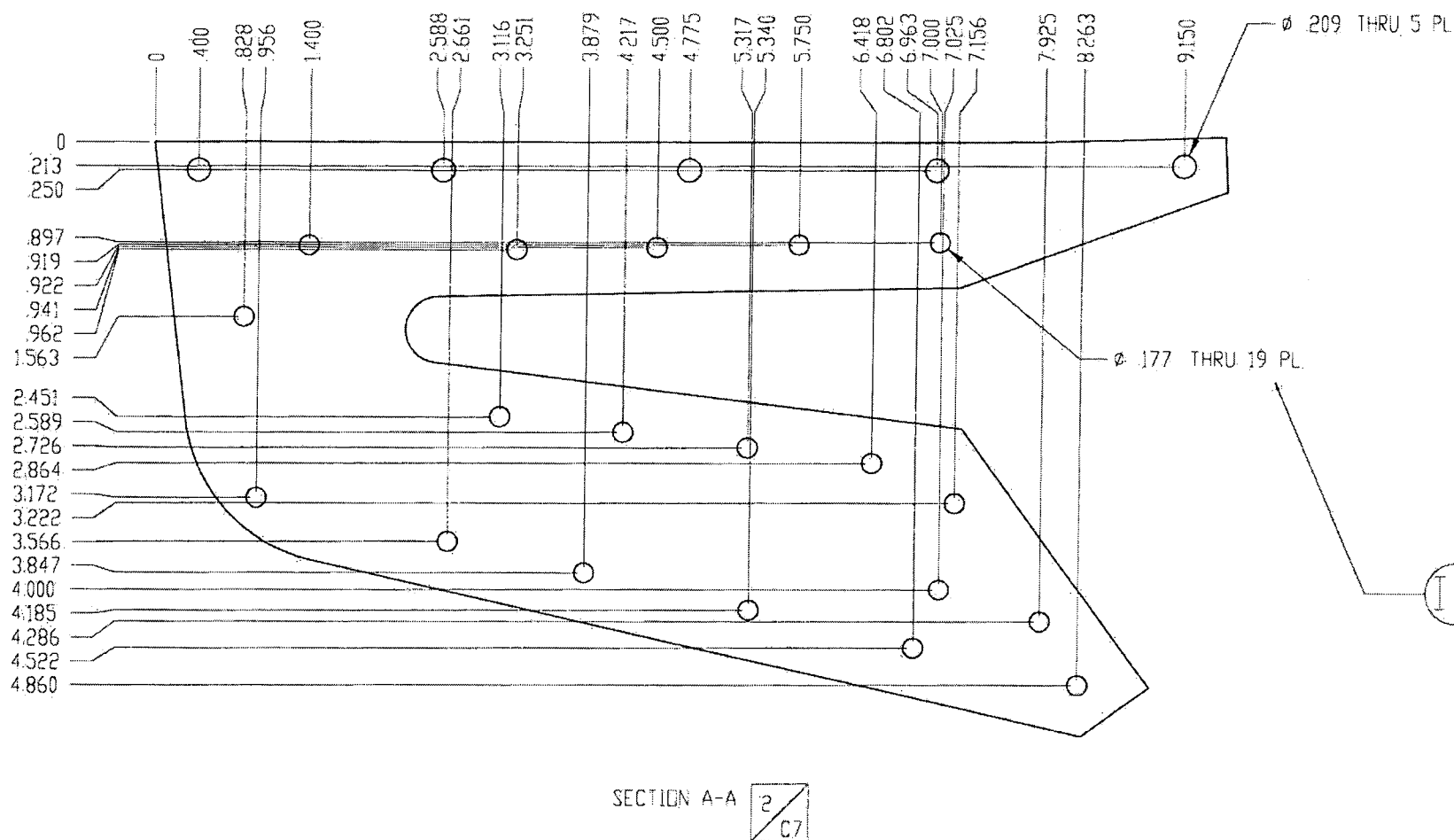
SHEET 1, ZONE D5, IS:



UNCONTROLLED
SUPERSEDED BY
WORK ORDER
NO. 130894 M/S
15-03-26

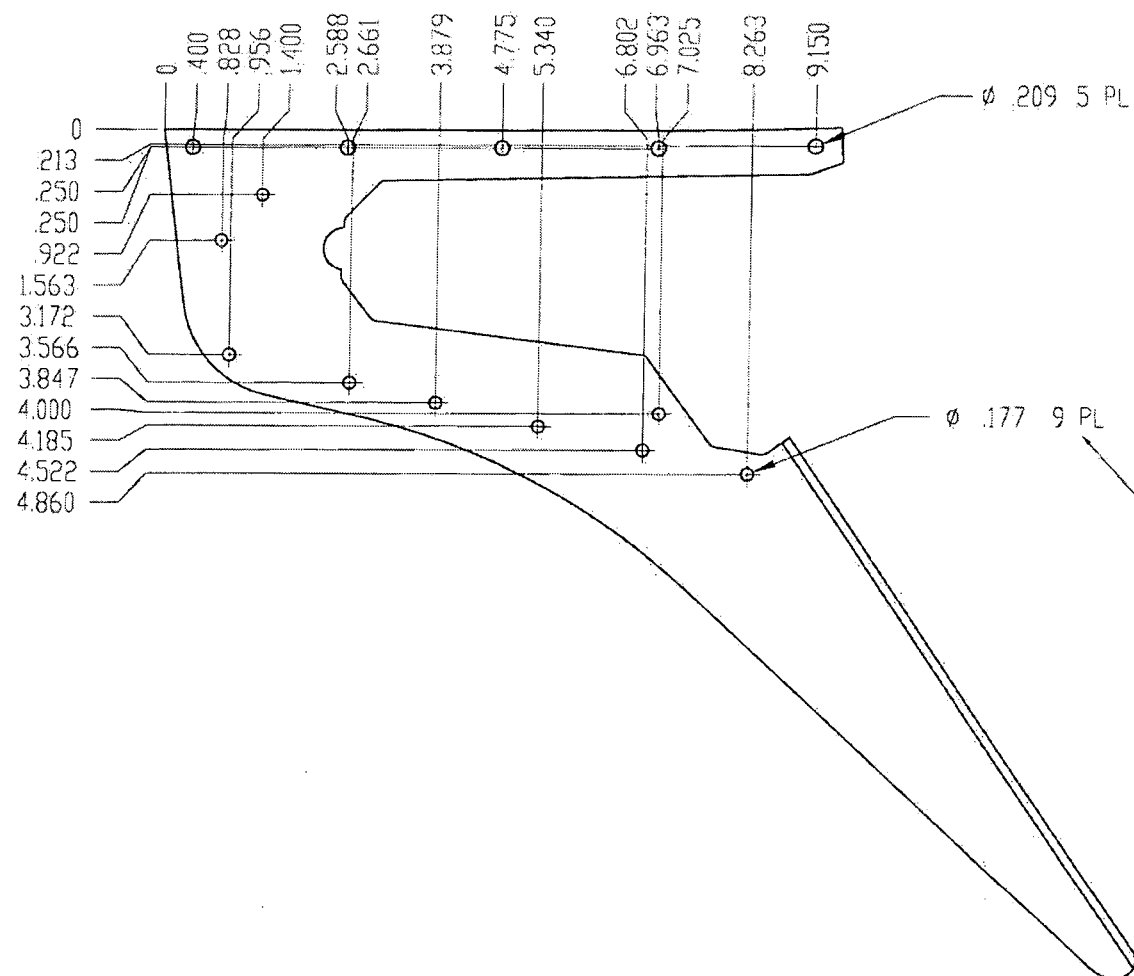
10	R	601.1541	19	LOCKNUT	MS21042L08
9	R	601.2764	38	WASHER	NAS1149FN832P
8	R	601.2765	19	SCREW	MS27039-0819
7	D	601.2766	2	RIVET	MS20470AD5-18
			3001		
F/N TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION	
DOCUMENTS EFFECTED:				CHANGE CATEGORY	DER REVIEW REQUIRED
☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM				☐ MAJOR ☒ MINOR	☐ YES ☒ NO

SHEET 3 IS:



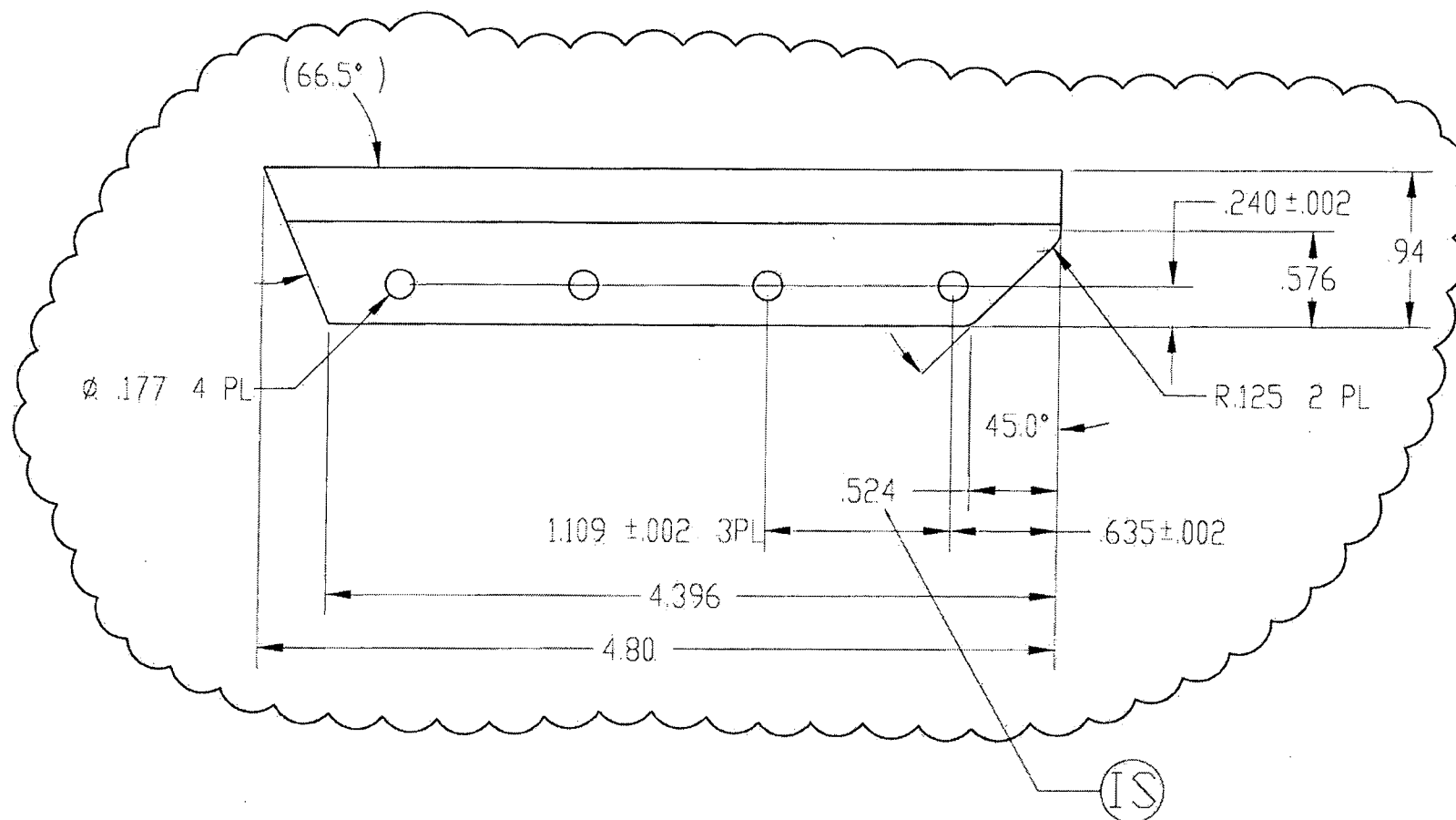
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 5 IS:



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

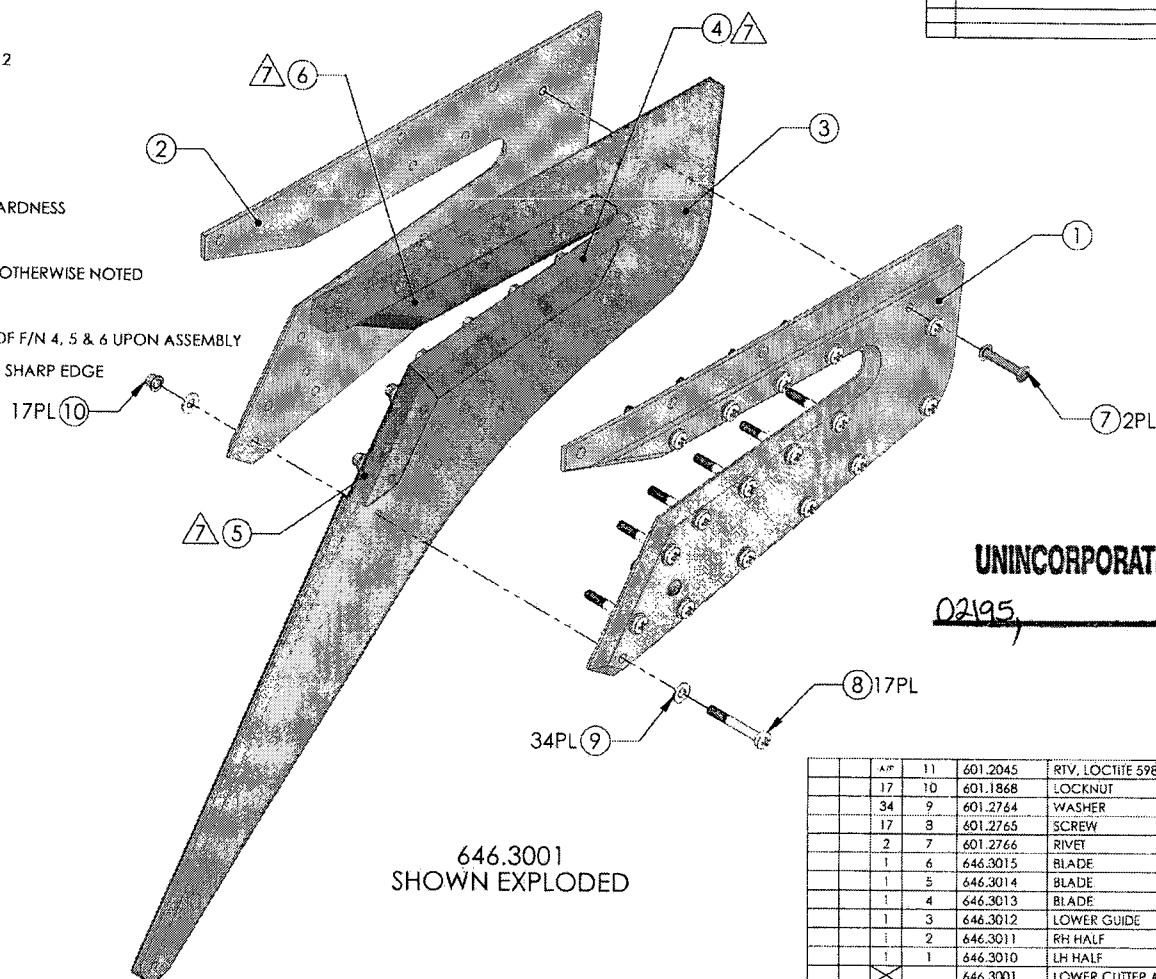
SHEET 6, ZONE C4, IS:



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

NOTES:

- 17PL(10)



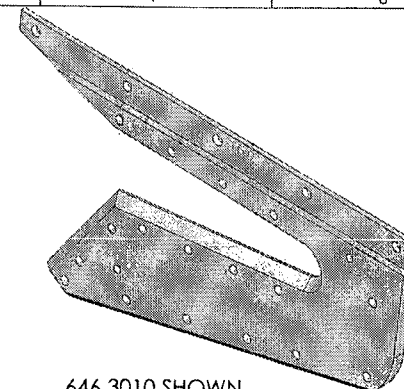
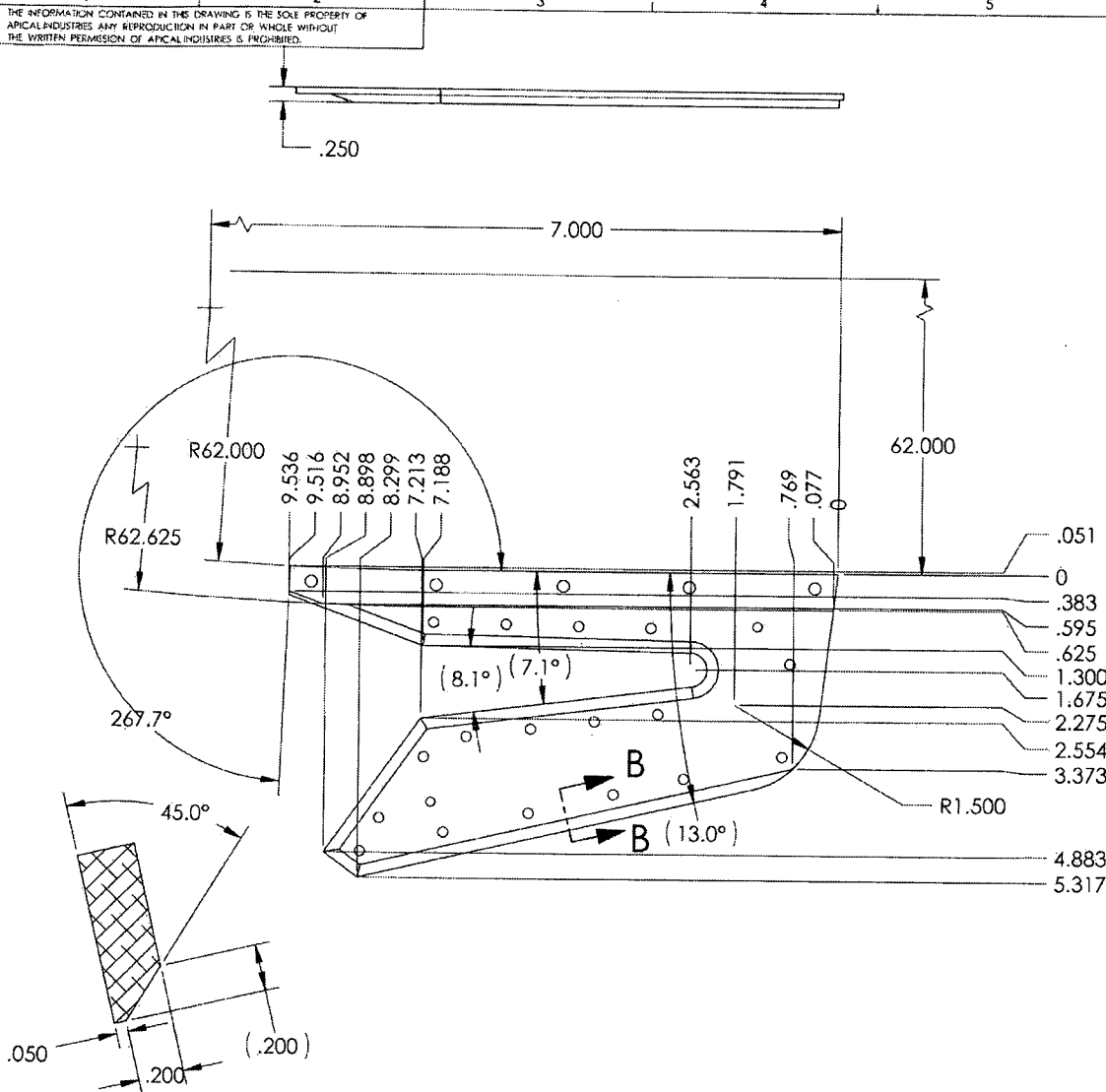
646.3001
SHOWN EXPLODED

UNINCORPORATED ECN(S)

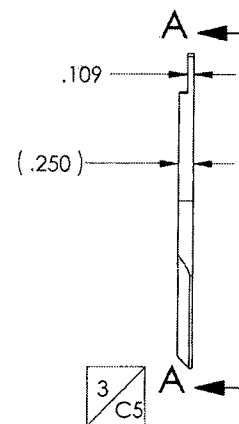
02195

	A7P	11	601.2045	RIV, LOCITE# 598			
	17	10	601.1868	LOCKNUT	MAS1543-0B		
	34	9	601.2764	WASHER	MAS1146FN-B32P		
	17	8	601.2765	SCREW	MAS2079-0B1A		
	2	7	601.2766	RIVET	MAS2087RAGS-1E		
	1	6	646.3015	BLADE			A
	1	5	646.3014	BLADE			A
	1	4	646.3013	BLADE			A
	1	3	646.3012	LOWER GUIDE			A
	1	2	646.3011	RH HALF			A
	X	1	646.3010	LH HALF			A
			646.3001	LOWER CUTTER ASSY			
QTY	UNIT	FIND #	PART #	DESCRIPTION	MATL	SPEC.	
NEXT ASSY (S)				PARTS LIST			
646.4000							

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646.3010 SHOWN
646.3011 OPPOSITE

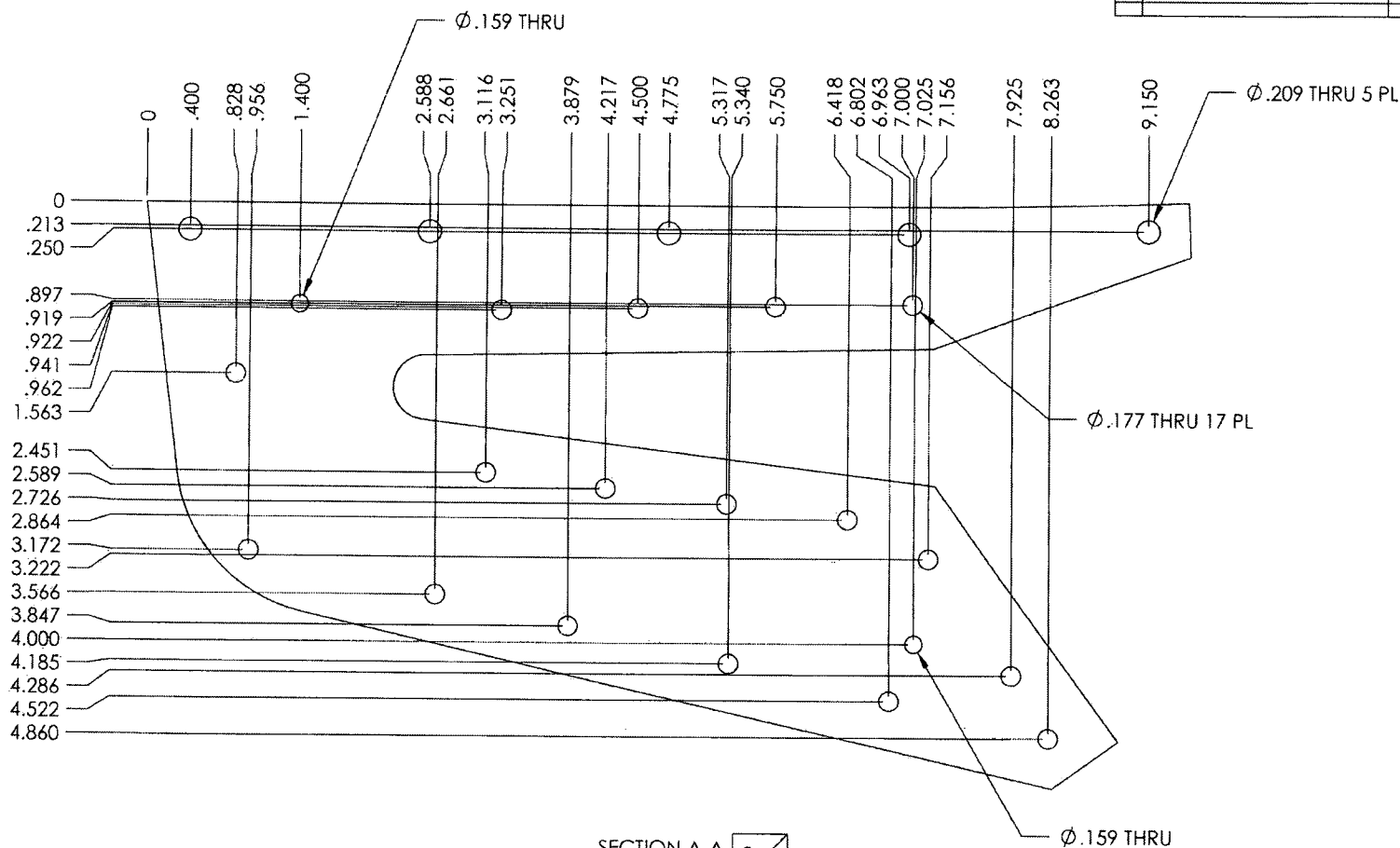


SECTION B-B
TYP EDGE DETAIL

ORIGINAL DATE: 06-26-06		APICAL INDUSTRIES	
DRAWN BY: CHUCKER		2608 TEMPLE HEIGHTS DR.	
P. BRAVO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL: JOSEPH		LOWER CUTTER ASSY	
CONTRACT NO.		646.3000	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE DECIMALS .01 ANGLES ± .5°		CAGE CODE: 07M16	REV: N/C
SCALE: NONE		SHEET 2 OF 8	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

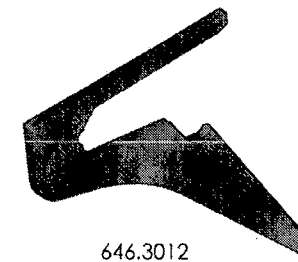
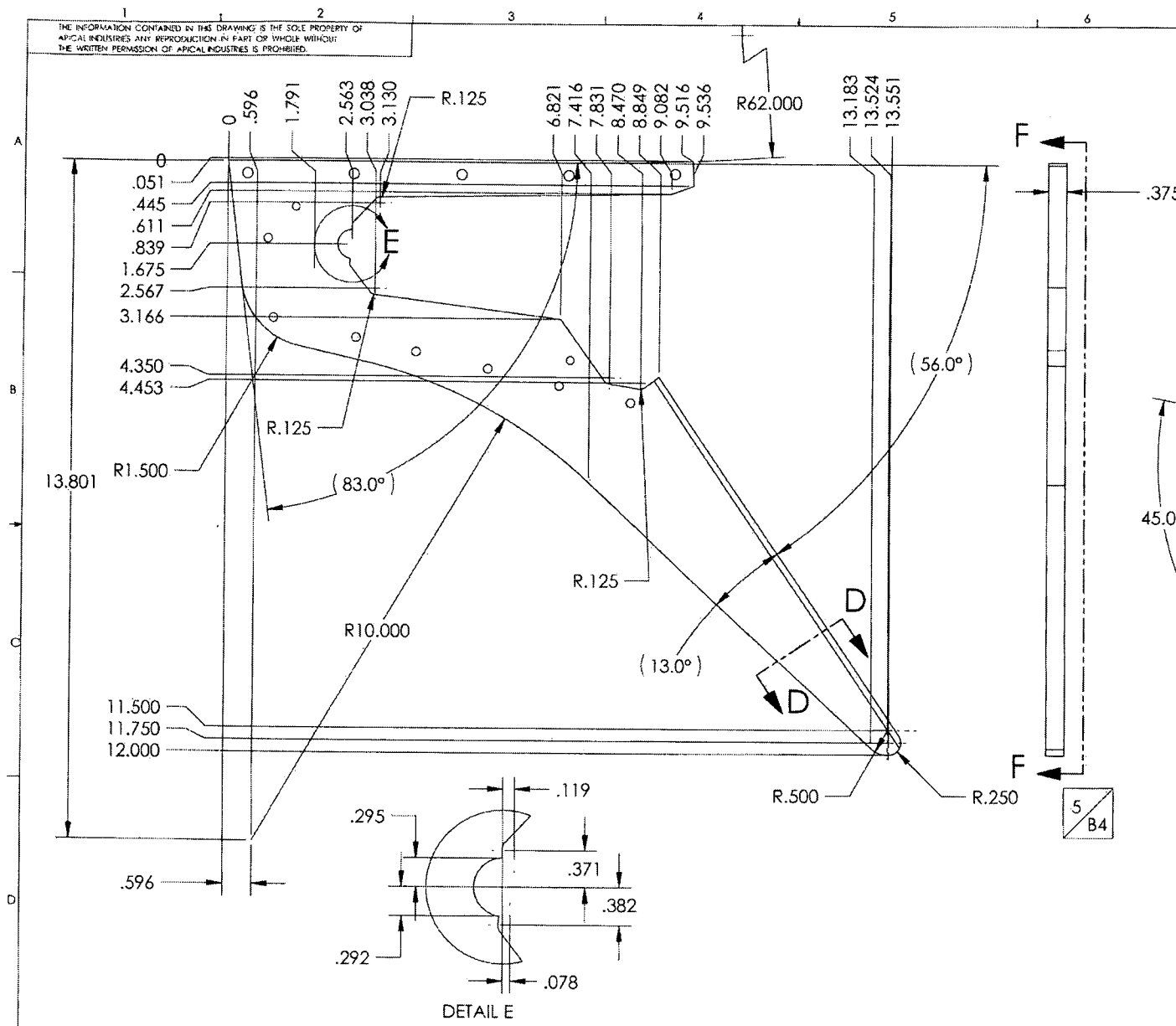


SECTION A-A 2/7 C7

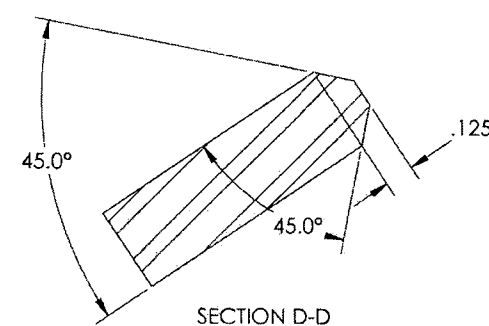
ORIGINAL DATE JANUARY 1988		APICAL INDUSTRIES	
DRAWN BY: J. B. V. O.		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. B. V. O.		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL J. B. V. O.		LOWER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		REV. NO. 646.3000	REV. N/C
SCALE NONE		SHEET 3 OF 8	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



646.3012

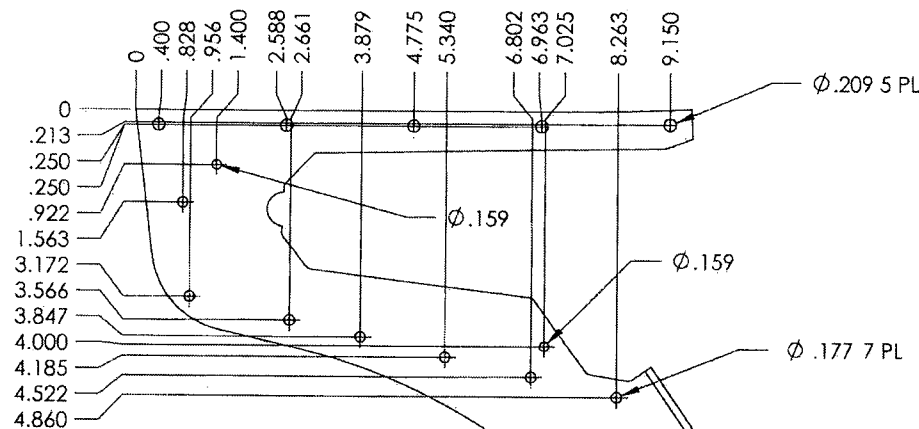


SECTION D-D

ORIGINAL DATE (M/D/Y) 08-26-05 DRAWN BY P. BRAVO CHECKED BY S. JOSEPH DRAWING APPROVAL S. JOSEPH CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±.01 DECIMALS DECIMALS ±.005 ANGLES ±.5°		LOWER CUTTER ASSY	
SHEET 8	CAGE CODE 07MA26	DWG. NO. 646.3000	REV. N/C
SCALE NONE		SHEET 4 OF 8	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

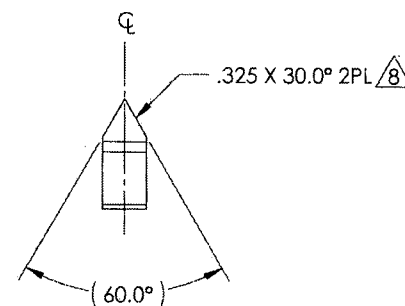
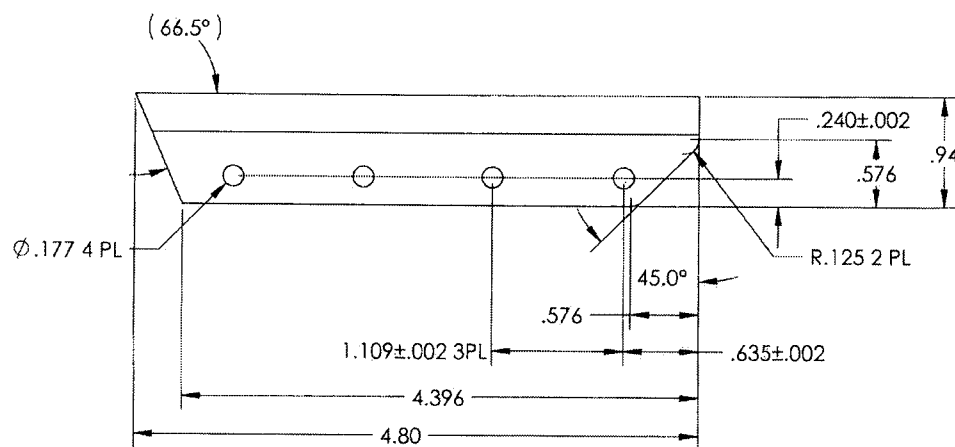
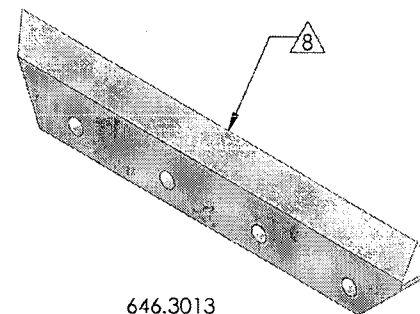
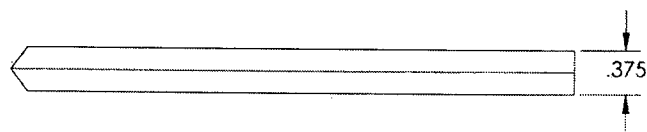


SECTION F-F 4
86

ORIGINAL DATE (MM-DD-YY) 08-28-08	APICAL INDUSTRIES			
DRAWN BY: JOSEPH P. BRAYO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300			
DRAWING APPROVAL: JOSEPH P. BRAYO 08-28-08	LOWER CUTTER ASSY			
CONTRACT NO.	SIZE B	CAGE CODE 07M26	QWTS INCL 646.3000	REV. N/C
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS $\pm .01$ ANGLES $\pm .5^\circ$	SCALE NONE		SHEET 5 OF 8	

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE
(MO-DA-YR) 08-26-68
DRAWN BY J. CRECHT
I. BRAYCO J. JOSEPH
DRAWING APPROVAL
J. JOSEPH
BY DATE
CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS ARE
2 PLACE DECIMALS ± .01
ANGLES ± .5°

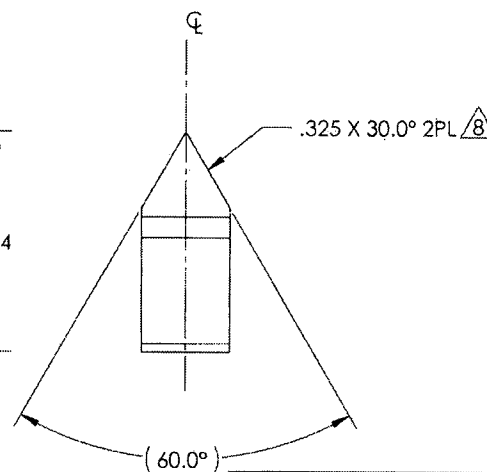
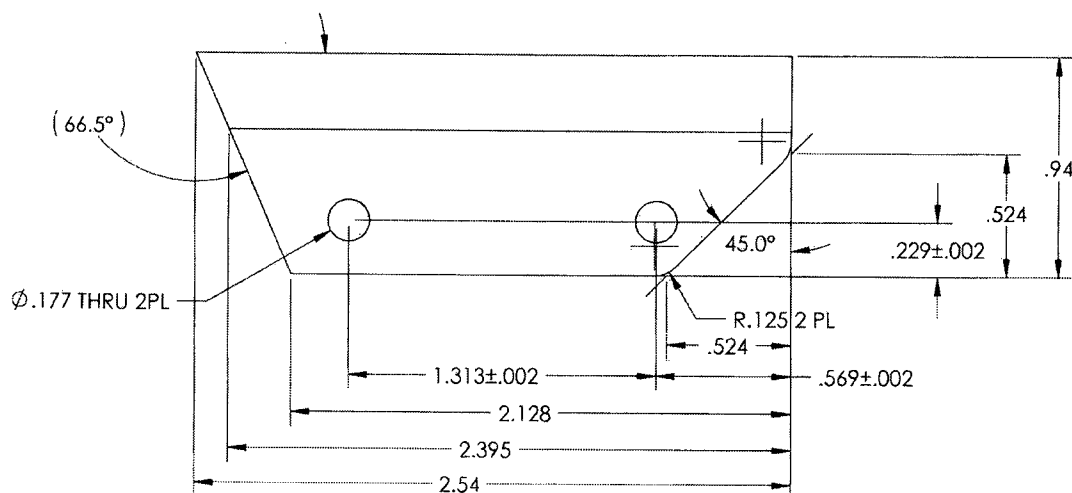
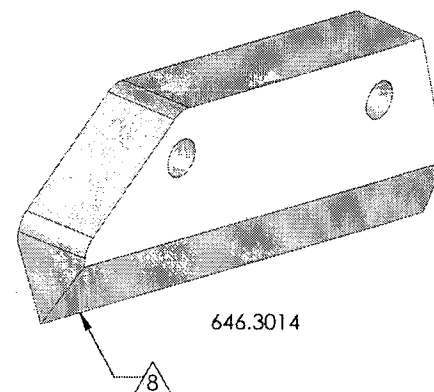
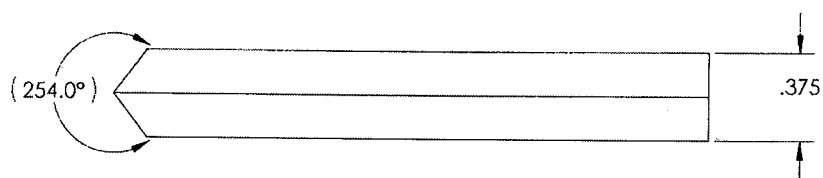
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

LOWER CUTTER ASSY

SHEET	8	CAGE CODE	07M26	DWG. NO.	646.3000	REV	N/C
SCALE NONE						SHEET 6 OF 8	

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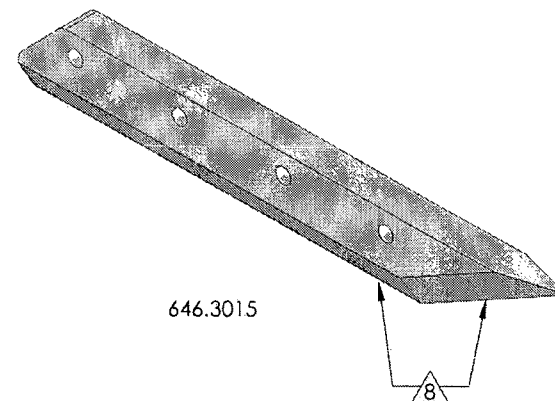
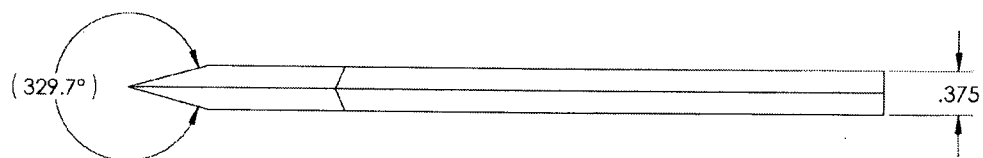
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



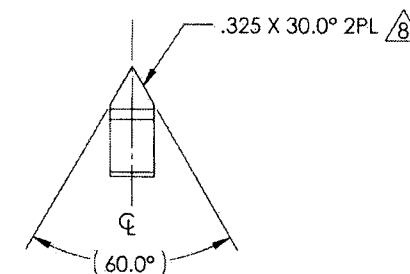
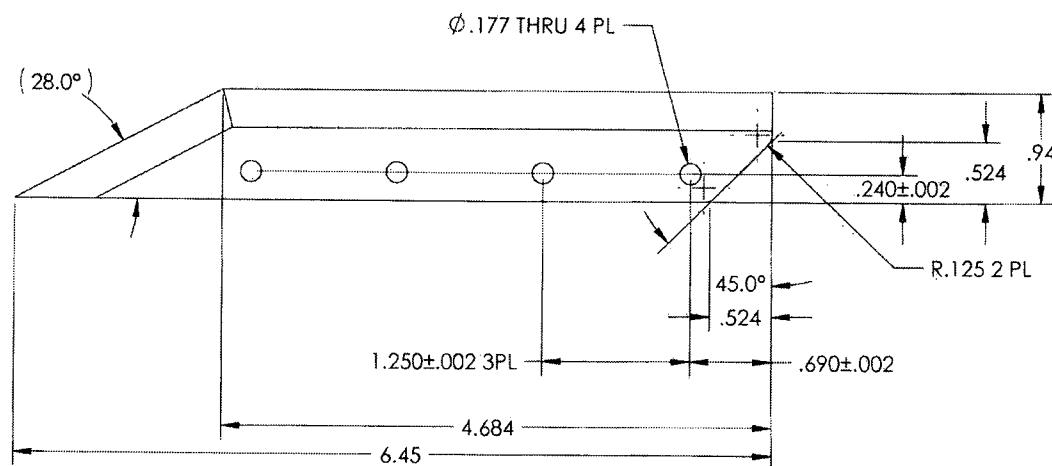
ORIGINAL DATE: (M/D/Y) 08-26-18	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056 3512 (760) 724-5300												
DRAWN BY: P. BRAYO													
CHECKED BY: J. JOSEPH													
DRAWING APPROVAL: J. JOSEPH													
CONTRACT NO.													
LOWER CUTTER ASSY													
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°	<table border="1"><tr><td>SHEET</td><td>CAGE CODE</td><td>END. NO.</td><td>REV.</td></tr><tr><td>B</td><td>07M16</td><td>646.3000</td><td>N/C</td></tr><tr><td colspan="2">SCALE: NONE</td><td colspan="2">SHEET: 7 OF 8</td></tr></table>	SHEET	CAGE CODE	END. NO.	REV.	B	07M16	646.3000	N/C	SCALE: NONE		SHEET: 7 OF 8	
SHEET	CAGE CODE	END. NO.	REV.										
B	07M16	646.3000	N/C										
SCALE: NONE		SHEET: 7 OF 8											

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REV	DESCRIPTION	DATE	APPROVED



646.3015



ORIGINAL DATE IND-DA-111 06-24-08	APICAL INDUSTRIES		
DRAWN BY P. BRAYO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
CHECKED BY S. JOSEPH	LOWER CUTTER ASSY		
DRAWING APPROVAL S. JOSEPH	REV. 1	QAGE CODE	DWG. NO.
CONTRACT NO.	B	07M26	646.3000
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$	SCALE	NONE	SHEET 5 OF 8



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28086**

Purchase Order Date 4/13/2015

PO Print Date 4/13/2015

Page Number 1 of 3

Order From :

VC-MET004

Ship To : DART AEROSPACE LTD

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450 473 1884

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							
1	130894	646.3013 BLADE	4/27/2015		6.00	\$0.00	\$0.00
		Yes					
		4/27/2015					
FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS							
PART ARE MADE FROM AISI A2 TOOL STEEL							
PLEASE NOTE: DETAIL C OF C REQUIRED							
						Line Total:	\$0.00
2	130960	646.3014 BLADE	4/27/2015		6.00	\$0.00	\$0.00
		Yes					
		4/27/2015					
FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS							
PART ARE MADE FROM AISI A2 TOOL STEEL							
PLEASE NOTE: DETAIL C OF C REQUIRED							

Note:

4/13/2015

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
301566	1	101624

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
28086		A2	2015/4/15	FEDEX

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-------------------------	--------------------------------	---	-----------------

32 646.3013 BLADE

(6) 646.3013 130894

(6) 646.3014 130960

(20) 646.9711 130845

1 BOITE DE CARTON

9,

SP15-04-28
SP15-04-28

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 32

POIDS EXPÉDIÉ / Weight Shipped : 9,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE /Quantity Shipped: 32

POIDS EXPÉDIÉ / Weight Shipped : 9,00

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Rapport d'Inspection**Inspection Report**

BON DE TRAVAIL order	CHARGE load
301566	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
28086		A2		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	5	59 - 60 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
32	9	646.3013 BLADE (6) 646.3013 130894 (6) 646.3014 130960 (20) 646.9711 130845 1 BOITE DE CARTON		

SPRS 01-28

24 April

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

[Signature]

DATE: 2015-04-17

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
301566	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
28086		A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	5	59 - 60 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
32	9	646.3013 BLADE (6) 646.3013 130894 (6) 646.3014 130960 (20) 646.9711 130845 1 BOITE DE CARTON		

COMMENTAIRES / comments

VAC HARDEN 1800F, 1:30 HR
DOUBLE TEMPER 400F, 2 HRS
L

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

APPROUVÉ par / Approved by:

Isabel Otero
QA Technician

DATE: 2015-04-24